

Work Order ID 164618

Tuesday, July 25, 2017 7:54:23 AM

164618

Page 1

Item ID: D4956-37

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Aft

Start Date: 7/26/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/28/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUL 25 2017 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4956	A

100

0.00

100

Waterjet

Memo

0.51

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.04

Quality Control

(4) _____ 07/27/2017

(4) _____ 07/27/2017

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Page 2

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.08

Quality Control

DAS

38

9-89

JUL 26 2017

130

Form as per dwg

0.33

130

Brake NC

Memo

1.16

Brake NC

31

JUL 27 2017

DAS

19

9-89

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.08

Quality Control

DAS

38

9-89

AUG 01 2017

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Page 3

Item ID: D4956-37 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Aft
Start Date: 7/26/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/28/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							DAS 41 9-89
150						4			
HandFinish	Memo	0.28							
Hand Finishing	1- After finish, coat entire top (concave) surface as per note 2 dwg D4956. TEXTURED COATING B#: <u>137803</u>								AUG 02 2017
160	QC3- Inspect Part Finish	0.00							DAS 38 9-89
160						4			
QC	Memo	0.04							
Quality Control									AUG 03 2017
170	Identify as per dwg & Stock Location: <u>FP-00</u>	0.00							
170									
Packaging	Memo	0.04							
Packaging	LOCATION : FP002								4 x of all 12/08/02

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Page 4

Item ID: D4956-37

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Aft

Start Date: 7/26/2017 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 7/28/2017 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.40

Quality Control

DAS
21
9-89

AUG 03 2017

Picklist Print

Tuesday, July 25, 2017 7:54:26 AM

Page 1

Work Order ID: 164618

164618

Parent Item: D4956-37

D4956-37

Parent Item Name: Wearplate Aft

Start Date: 7/26/2017

Required Date: 7/28/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased				100	sf	52.8000	0.78	3.284210			

M304S20GA

304/316 .040 Sheet

07/27/2017

Location

Loc Qty

Loc Code

MAT020

52.8

m137513

15.3

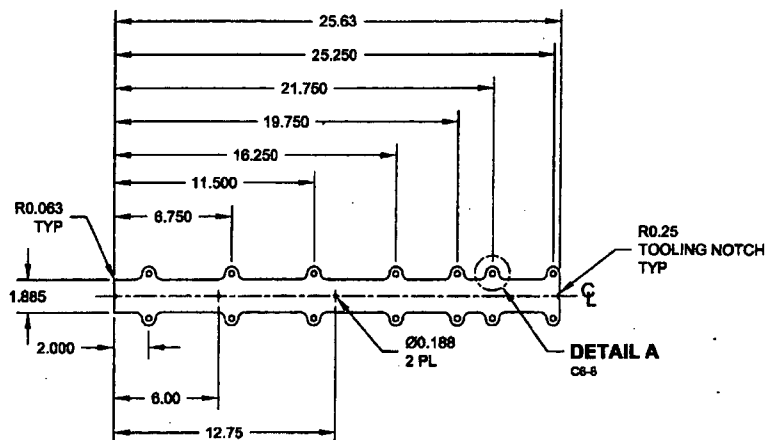
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8.7

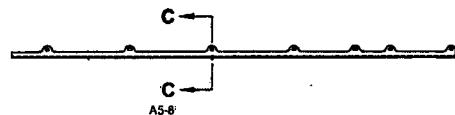
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28.8

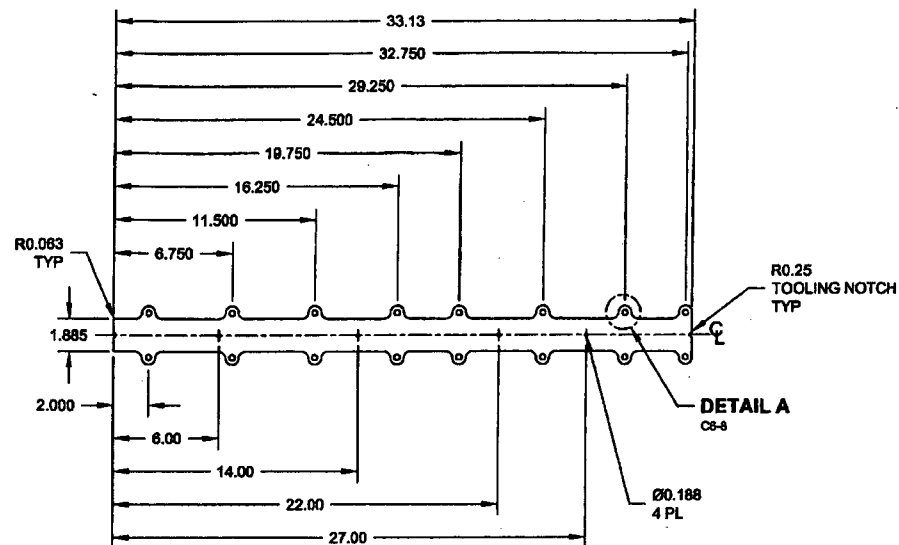
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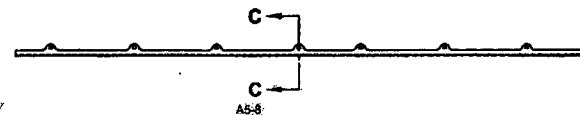
D4956-35F FLAT PATTERN



D4956-35 WEARSHOE
(MAKE FROM D4956-35F)



D4956-37F FLAT PATTERN



D4956-37 WEARSHOE
(MAKE FROM D4956-37F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164618 MLC
170725

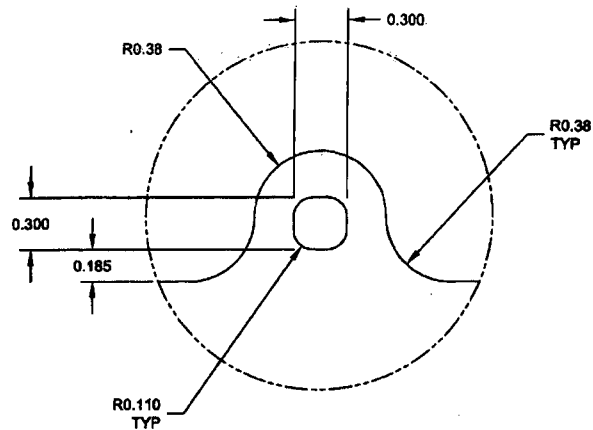
RELEASED
2014-04-17

NOTES

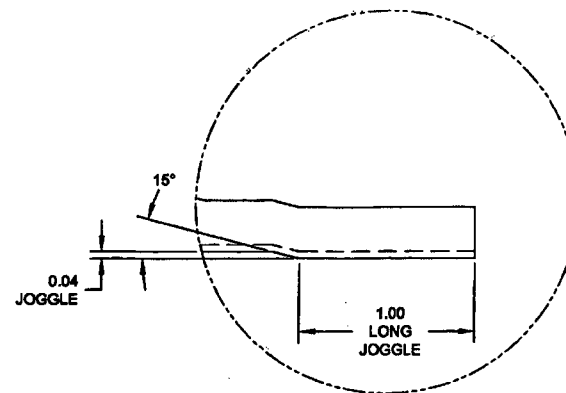
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4956-35 = 0.60 lbs; D4956-37 = 0.78 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D4956 SHEET 8 OF 8
APPROVED		TITLE SCALE
DE APPR.		WEARSHOE NTS
DATE	13.09.26	COPYRIGHT © 2013 BY DART AEROSPACE LTD

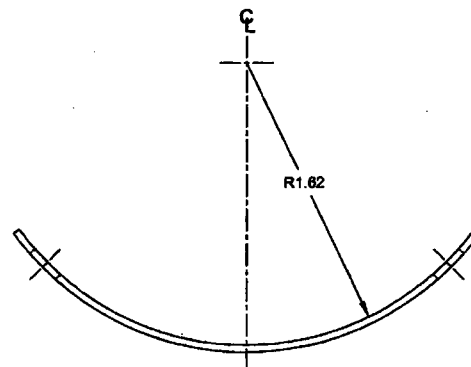
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DETAIL A C8-1 C4-1
C8-2 C1-3
C8-3 C1-3
C2-4
C6-5 C2-5
C8-6 C2-6
C4-7 C3-7



DETAIL B B6-1 B2-1
B3-2
B5-3 B1-3
B2-4
B4-7 B1-7



SECTION C-C B7-1 B3-1
B5-2
B7-3 B3-3
B8-4
B7-6 B3-5
B7-6 B3-6
B7-7 B3-7

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2014-04-17
MP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.		D4956	SHEET 6 OF 8
APPROVED	MP	TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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